

Work Order ID 55019

January 5, 2010 12:58:48 PM



Page 1

Item ID: D2857-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 24.00

33



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 24.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

DF

Date: 10-1-05

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2857

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

DTA
10/01/14

Jeaspa Bandsaw

Cut blanks 5.2"

24
+
9

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

mmf
10/01/10

HAAS CNC vertical machine #1

1-Machine per folio D2857-1 2-Deburr any rough edges

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

mmf
10/01/10

Quality Control

Ph →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2857-1 PAR #: _____ Fault Category: Machining NCR: Yes No 2 DQA: 2 Date: 10-01-29
 Resolution: Scrap / Accepted Disposition: Scrap / Use as is QA: N/C Closed: 2 Date: 10-01-29

NCR: <u>55019</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/18	110	-Dimension .147 is off because 4 axl was not well instal - 3 parts ac.: operator error / LOA	<u>AB</u> 09/21/18	Scrap and replace x3 <u>M 113608</u> x3	<u>MWD</u> 10/01/18	<u>S</u> 10/01/18	<u>AB</u> 09/21/18	<u>S</u> 10/01/19
10/01/19	120	During inspect. (QCS) Found that max Dim 0.150" is max 0.130". QTY + 34 affected RC offset was not correct / LOA	<u>CP</u> 10.01.19 pcv QSI 042-18	Acceptable Cosmetic	<u>1/4</u>	<u>S</u> 10/01/19	<u>CP</u> 10.01.19 pcv QSI 042-18	<u>S</u> 10/01/19
10/1/19	120	0.611 DIM IS UP TO 0.624"	<u>CP</u> 10.01.19 pcv QSI 042-18	Acceptable. Sufficient tolerance in assembly	<u>1/4</u>	<u>S</u> 10/01/19	<u>CP</u> 10.01.19 pcv QSI 042-18	<u>S</u> 10/01/19

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

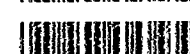
Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

88 10/01/19

33

3

Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00

HandFinish

Memo

0.00

M 10/01/20

33

9

Hand Finishing

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

=> 506.120

33

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55019

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Revision ID:

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Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 24.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 24.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

M118170

0.00

=> 10/01/20

33

φ

Powder Coating

START TIME: 11:30AM OVEN TEMPERATURE:
12:00PM FINISH TIME 320°F

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BR 10-01-20

(33)

φ

Quality Control

180

Identify as per dwg & Stock Location: 26

0.00



Packaging

Memo

0.00

10-1-21

(33X) SP

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55019

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Item Name: Hinge Bracket

Start Date: 05/01/2010 Start Qty: 24.00

Required Date: 15/01/2010 Req'd Qty: 24.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/259

MF 10-1-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 5, 2010 12:58:52 PM

Page 1

Work Order ID: 55019

Parent Item: D2857-1

Parent Item Name: Hinge Bracket

Start Date: 05/01/2010

Required Date: 15/01/2010

Start Qty: 24.00

Required Qty: 24.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No		100	f	19.7474	11.0526			



6061-T6 Bar 2.00 x 1.25



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	19.74736842	
105838	12	
110936	7.74736842	

6061-t6 B20x1.25 M113608

11.0526 (F)
+
4,1447 (F)

DTT
10/01/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55019
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.302	✓			
4.000	+/-0.010	4.000	✓			
0.340	+/-0.010	.340	✓			
1.110	+/-0.005	1.110	✓			
1.790	+/-0.010	1.790	✓			
1.320	+/-0.005	1.32	✓			
2.000	+/-0.010	2.001	✓			
0.340	+/-0.010	.340	✓			
0.447	+/-0.010	.447	✓			
Ø0.171	+0.005/-0.000	Ø.175	✓			
0.147	+/-0.010	.146	✓			
0.376	+/-0.010	.376	✓			
0.126	+/-0.010	.127	✓			
0.063	+/-0.010	.067	✓			
Ø0.166	+0.005/-0.000	Ø.168	✓			
0.911	+/-0.010	.909	✓			
0.600	+/-0.010	.591	✓			
0.125	+/-0.010	.126	✓			
0.150	+/-0.010	.140	✓			

Measured by: MW	Audited by: BF	Prototype Approval:	N/A
Date: 10/01/18	Date: 10/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

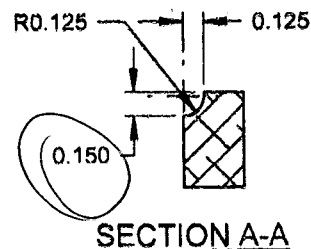
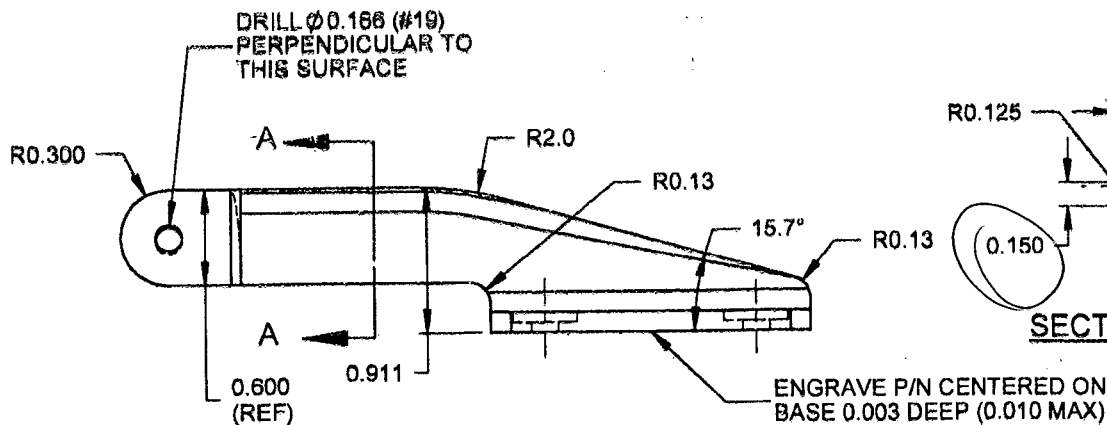
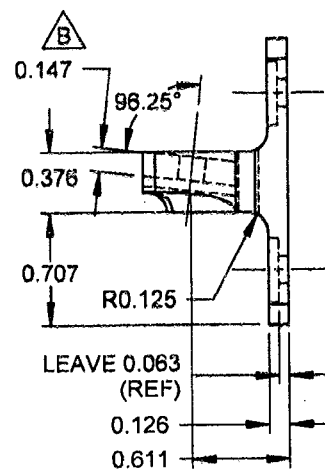
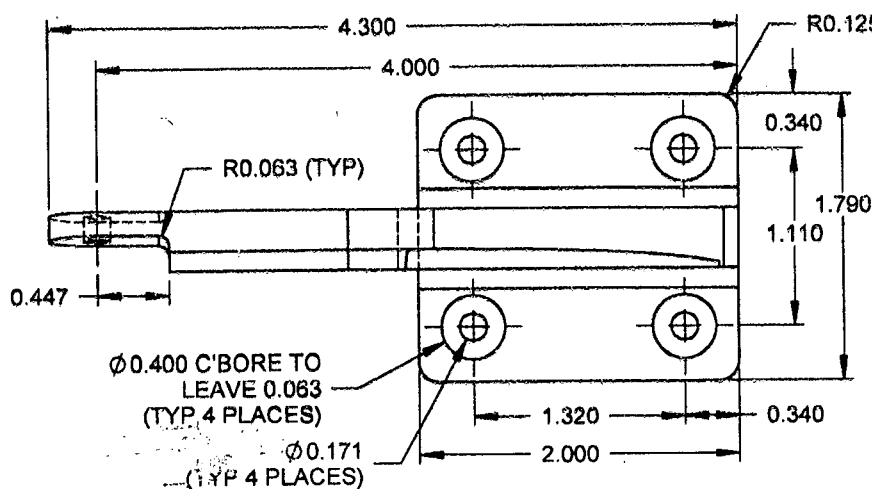
SUBJECT TO
WITHOUT
WORK

DART

NO. 58619
BL 10-1-05

DESIGN KE	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28	TITLE HINGE BRACKET		SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS. REDRAW W/ SOLIDWORKS	

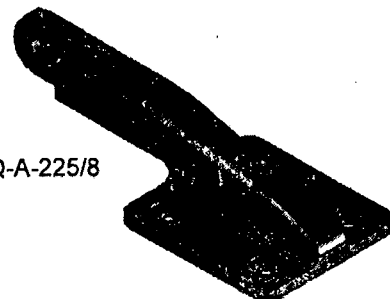
RELEASED
06-10-13



D2857-1 HINGE BRACKET
D2857-2 OPPOSITE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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